

Work Order ID 158156***158156***

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Monday, March 13, 2017 1:57:27 PM

Item ID: D4131-9 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Label Plate
Start Date: 3/15/2017 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 3/16/2017 Req'd Qty: 6.00 ***6*** Customer:
Reference: SCHEDULE/S

Approvals: Process Plan: DAS 21 Date: MAR 13 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4131	C								

100

0.00

100Waterjet
FLOW CNC Waterjet**Memo**1-Cut as per Dwg
Dwg Rev: C
Prog Rev: C

2-Deburr if necessary

0.06

(6)

DAS
46
9-89

17/03/15

ac 17/03/16

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110QC
Quality Control**Memo**

0.01

(6)

ac 17/03/16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.02				6			DAS 38 9-89
Quality Control									MAR 16 2017
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.01				6			DAS 41 9-89
Packaging	LOCATION : GA						DAS 6 9-89		17-3-16
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.10							17/3/21
Quality Control									DAS 21 9-89 MAR 16 2017

Picklist Print

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Work Order ID: 158156

158156

Parent Item: D4131-9

D4131-9

Parent Item Name: Label Plate

Start Date: 3/15/2017

Required Date: 3/16/2017

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 11.09.26 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA		Purchased	No			100	sf	134.4950	0.0169	0.106737			

M304S22GA

304/316 .032 Sheet

02/17/03/16

Location

Loc Qty

Loc Code

MAT020

134.495

m126593

0.975

m134399

35.82

m135192

33.7

m136896

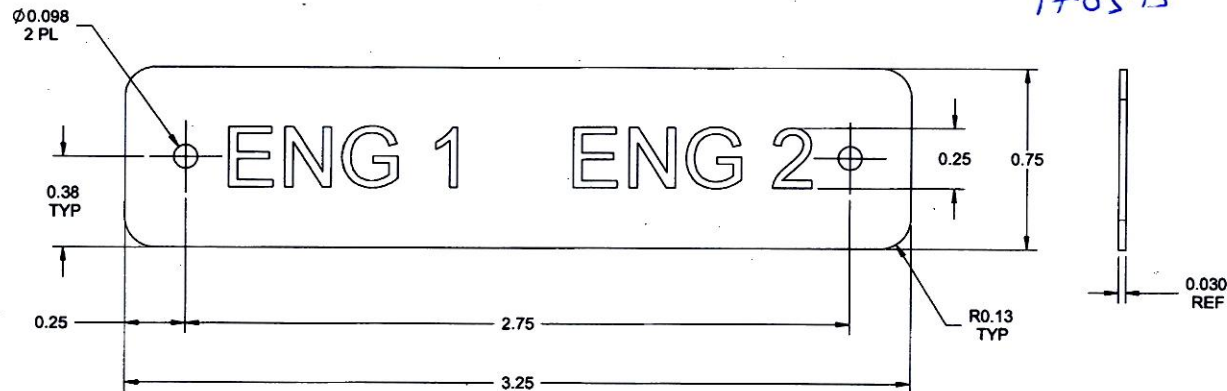
64

131999

.2

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 158156 MJS
1703-13

ENG 1 ENG 2



D4131-9 LABEL PLATE

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.030 (22 GAUGE) SHEET
PER MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
PER DART SPEC. M304S22GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

RELEASED
2014-10-20
MP

APPROVED	DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
	DRAWN	RF		
	CHECKED	VS	DRAWING NO.	REV. C
	MFG. APPR.	JFS	D4131	SHEET 10 OF 10
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	MANIFOLD ASSEMBLY	NTS
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